

Start April 30 - Eagle

Dart Aerospace Ltd.

Date: Monday, 4/23/2007 1:55:35 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 -Dart Helicopters Services	Drawing Name	: PILOT/CO-PILOT STEP, RH (FOLDING)
Job Number	: 32000		
Estimate Number	: 12027		
F.O. Number	: N/A	Part Number	: D412630024
This Issue	: 4/23/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D412-630 REV K
First Issue	: N/A	Project Number	: N/A
Previous Run	: 30540	Drawing Revision	: K
		Material	: N/A
		Due Date	: 5/4/2007
Written By	:	Qty:	1 Um: Each
Checked & Approved By	:		
Comment	: Est. Rev: B 05.08.22 Step 3 & 5 revised per ECN 700 KJ/JL M Est Rev:C As per Rev K 06-11-10 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-024 CHG003

KJ

07.04.30

2.0	D2012107	Clevis
-----	----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description	Batch
1	D2012-107	Clevis	B29883 -

3.0	D2803042	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2803-042	Bracket Assembly RH	B26564 -

4.0	D2804042	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2804-042	Bracket Assembly RH	B29409 B26252

mf 07-04-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:55:35 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 32000

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2807

Support Prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Support Prop

Pick:

Qty Part Number

Description
Gas Spring

Batch

B 28488 -

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer

Pick:

Qty Part Number

Description
Washer

Batch

B 26649 -

7.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bushing

Pick:

Qty Part Number

Description
Bushing

Batch

B 28455 -

8.0

D3388042

Step Weldment RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Step Weldment RH

B 32024 -

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
BOLT

Pick:

Qty Part Number

Description
Bolt

Batch

m101189 -

10.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut

Pick:

Qty Part Number

Description

Batch

MF 07-04-26

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 32000

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description:

2 AN310C8

Nut

m100433

11.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

2 AN8C16

Bolt

m100695-

12.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

4 MS21043-3

Nut

m102545-

13.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Cotter Pin

Pick:

Qty

Part Number

Description

Batch

2 MS24665-302

Cotter Pin (or AN380C3-4)

m16941-

14.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Screw

Pick:

Qty

Part Number

Description

Batch

2 MS24693-C280

Screw (or MS24694-C565)

m101390-

15.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

6 NAS1515H3

Washer

m100993-

MF 07-04-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 32000

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description:

16.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M101925-

17.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M101331 x 1mx, M102067 x 3mx

MF 07-04-26

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Coat hardware with LPS3 prior assembly. batch: M101472

2-Assemble as per dwg D412-630 p.13

3-Coat exposed hardware with LPS Procyon. batch: M17045

MF 07-04-27

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/04/27

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description
2	D2806-1	Bushing

Batch

M27285

7/4/27 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 32000

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description
2	D2806-3	Bushing

Batch



1527286 * / /

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Pick: Packing Kit

Qty	Part Number	Description
1	D2810-5	Strut

Batch

1529395 * / /

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Pick: Packing Kit

Qty	Part Number	Description
2	D3396-1	Spacer

Batch

1526771 * / /

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
1	AN4C6A	Bolt

Batch

1102039 * / /

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
1	AN4C10A	Bolt

Batch

1102273 * / /

7/4/27 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 32000

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

2 AN4C15A

Description

Bolt

Batch

M100229- ✓ ✓

28.0

AN44C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty Part Number

1 AN44-C7A

Description

Eyebolt

Batch

M101711- ✓ ✓

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

2 AN5C15A

Description

Bolt

Batch

M100229- ✓ ✓

30.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

4 MS21043-4

Description

Nut

Batch

M102989- ✓ ✓

31.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

3 MS21043-5

Description

Nut

Batch

M101418- ✓ ✓

7/4/23 SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:55:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 32000

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description
7	NAS1515H4	Washer

Batch

M101428 / -

33.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description
7	NAS1515H5	Washer

Batch

M100433

7/4/2759

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C. Boyer/30

u 07-04-30

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-024

Location:

PPP Rev:

C. Boyer/30

36.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

SD 07/04 L30

Job Completion



u 07-04-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D412-630-023/-024 Heli-Access-Step™ Installation

FIGURE 11 – STA 84.29 for D412-630-023/-024 Heli-Access-Step™ Installation

(View rotated 90° CW)

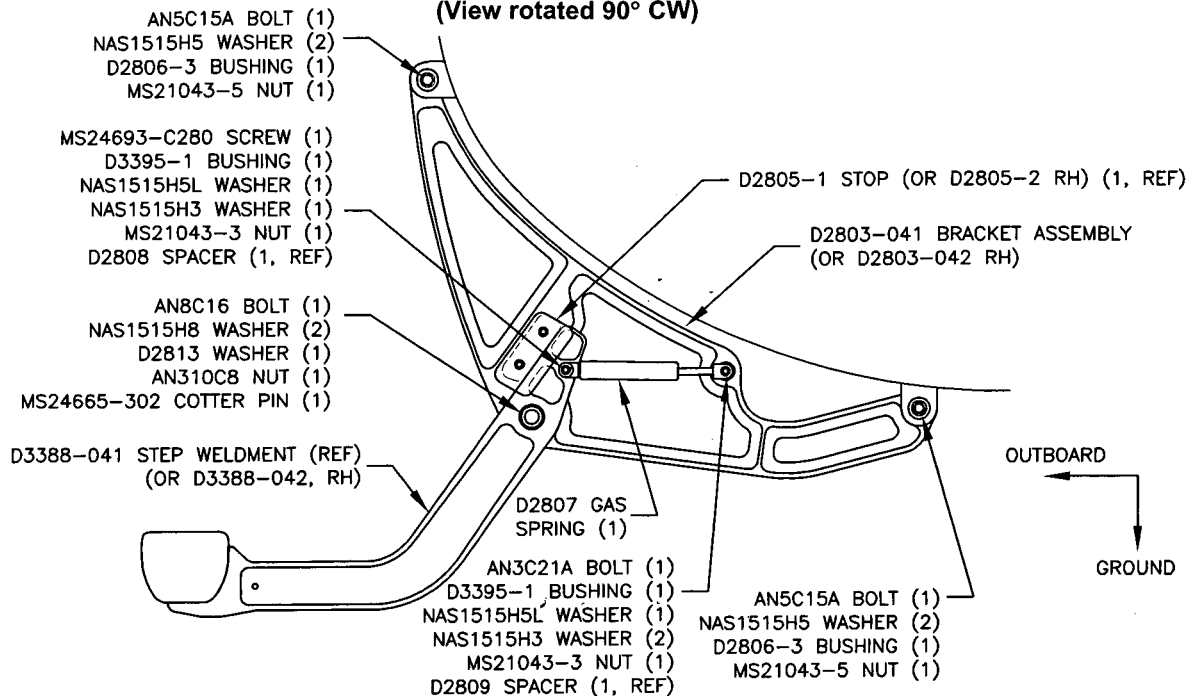


FIGURE 12 – STA 155.06 for D412-630-023/-024 Heli-Access-Step™ Installation

(View rotated 90° CW)

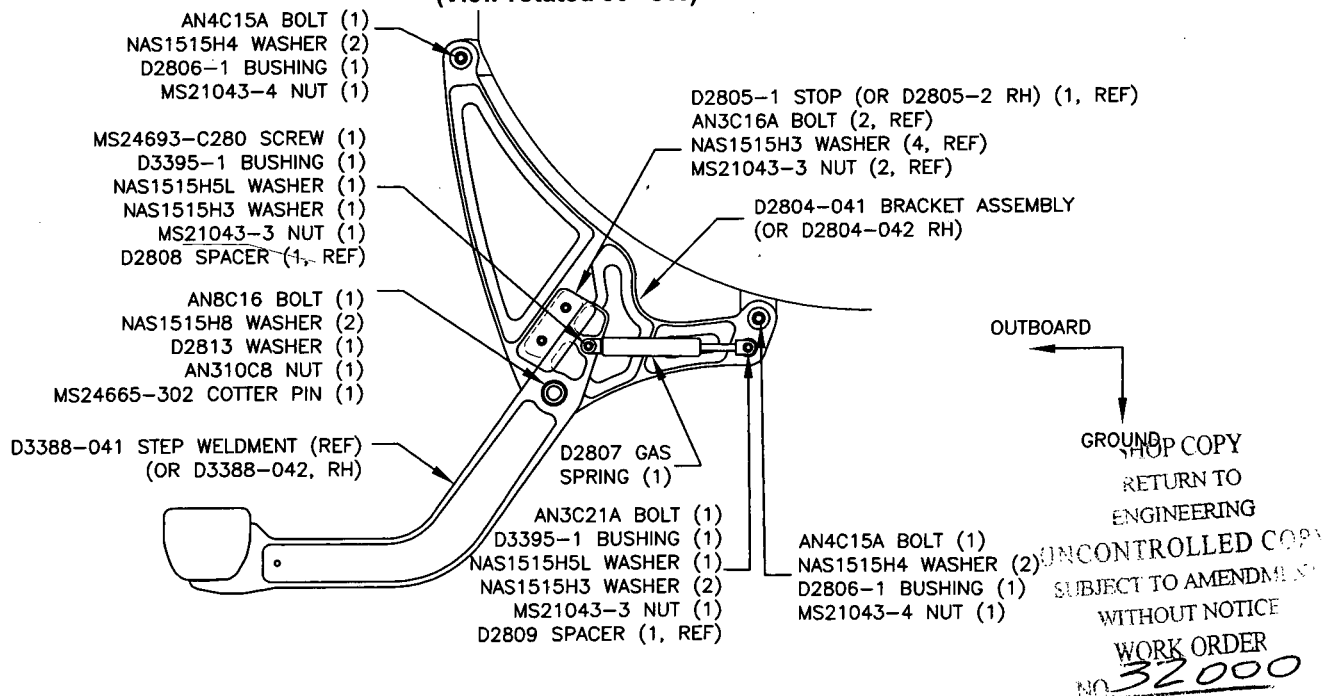
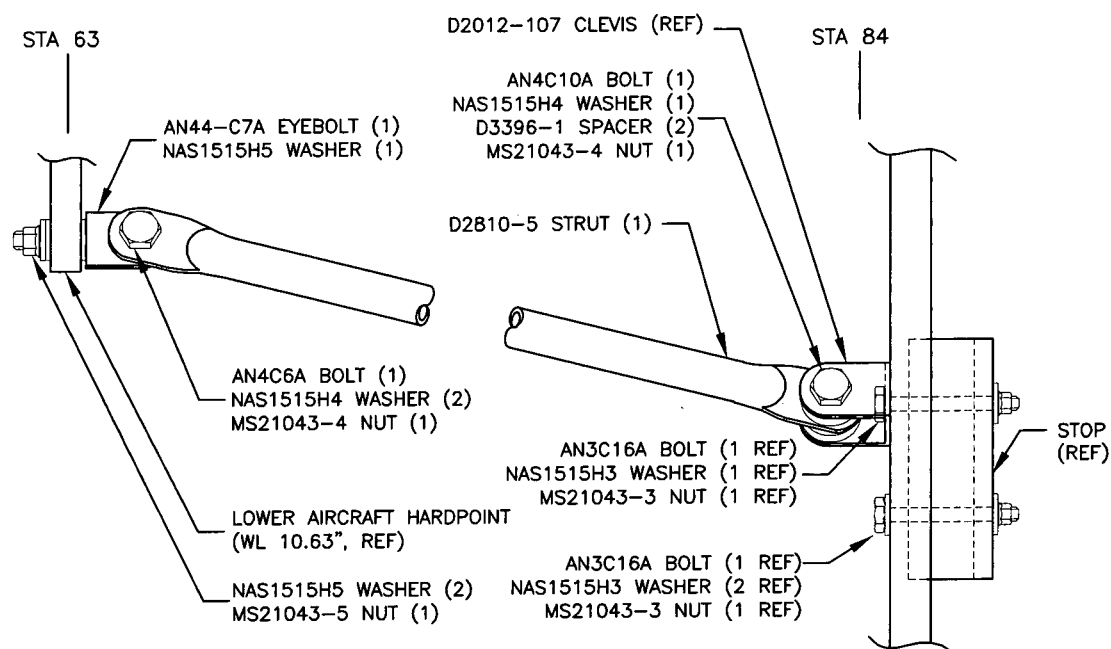


FIGURE 13 – Strut Detail for D412-630-023/-024 *Heli-Access-Step*™ Installation
(NOT TO SCALE)



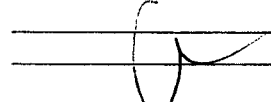
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32000

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Revision: **K**
Date: 06.10.05

Date: Monday, 12/11/2007 8:31:02 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D412-630-UPDATE PAPERW.
Job Number : 35612	
Estimate Number : 10804	
P.O. Number : N/A	Part Number : Z_CUSTOM
This Issue : 12/11/2007 S.O. No. : N/A	Drawing Number : ECN 1019
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : N/A
Previous Run : 00015	Material : N/A
Written By : 	Due Date : 19/11/2007 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : _____	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 REMOVE FROM STK:

D412-630-011G 34656
 D412-630-012G 34657
 D412-630-023 31816^(X) 27271 2x 26651 1x
 D412-630-024 32000
 D412-630-033 B 33576
 D412-630-034 B 33577

ADD NEW PAPERWORK TO KITS IN STK
 PER ECN 1019 - DSI 9386

RETURN TO STK

7-11-12 sel

2.0	QC21	FINAL INSPECTION/W/O RELEASE
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①

Comment: FINAL INSPECTION/W/O RELEASE

Dart 11/12

Job Completion



u 07.11.12